

June 25

Work Order ID 83774

83774

Page 1

April-25-12 10:12:58 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

119785
120854

10 \$

12.05.15

12.05.22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | | | | | | |
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

10 0 BE 12-05-23

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

8/10/23

(40)
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 7/6 12-5-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

QC3- Inspect Part Finish

0.00


150

QC

Memo

0.00

Quality Control

10X  12/05/24

180

0.00

180

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod M119785

6-Grind End Plate flush

7-Install last rivet as per Dwg.

(10)  12.05.28

12.05.29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 83774

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April-25-12 10:12:58 AM

Item ID: D350-591-312

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

8/12/05/30

8/12/05/30

X/D
FH

10X
RH
M-L
12/05/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Memo

START TIME:

3:45

0.00

Powder Coating

OVEN TEMPERATURE:

320 °C

FINISH TIME:

4:15

10X Ø
RH

MA
12/05/30

230

Wing Walk as per dwg QSI005 4.4 Batch M121 500.00

0.00

230

HandFinish

Memo

0.00

Hand Finishing

10RH d Malo 6/01

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

10 Ø BR 10-6-1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop ***NS2***

Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

10

12/06/08 JB

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

Subtotal

10

RH

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

10x

SP
12-6-7

Lev B

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Work Order ID 83774

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

280

QC Memo

Quality Control

0.00

12/6/8
MLJ 12/06/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-25-12 10:13:01 AM

Page 1

Work Order ID: 83774

83774

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3272-1 | | Manufactured | No | | | 110 | Each | 20.0000 | 1 | 10 | | | |

D3272-1

Step

**

Ac 12.05.05

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST | -10 | |
| WA | 30 | |
| 81312 | 10 | |
| 81313 | 10 | |

D3067-1

Manufactured No

110

Each

187.0000

1

10

**

12.05.15

D3067-1

End Plate

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 123 | |
| 78608 | 4 | |
| 80881 | 45 | |
| 81969 | 74 | |
| WA016 | 64 | |
| 67582 | 2 | |
| 68214 | 1 | |
| 79607 | 1 | |
| 83053 | 60 | |

10

9

1

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

April-25-12 10:13:02 AM

Page 2

Work Order ID: 83774

83774

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110 Each

323.0000

2 20

D3219-1

Plate

**

12.05.15

Location

Loc Qty

Loc Code

WA

84

82221

84

WA016

118

73410

12

77674

6

81292

80

82059

20

WA017

121

81971

121

20

D3066-1

Manufactured No

180 Each

101.0000

2 20

D3066-1

Spacer

**

B83854 (20) Ae 12.05.28

Location

Loc Qty

Loc Code

WA

101

81968

101

MS20600-AD4W4

Purchased No

180 Each

3,044.000

16 160

MS20600-AD4W4

Rivets

**

M118840 (160) Ae 12.05.28

Location

Loc Qty

Loc Code

ST321

3044

121011

9

121340

1035

121444

2000

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID: 83774

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180 Each

19.0000

1 10

**

880880

(10) Ae
12.05.28

D3065-041

Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180 Each

187.0000

1 10

**

12.05.29

D3067-1

End Plate

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased No

250 Each

127.0000

**

10
20 ✓

12.6.52 JB 12/06/01
S u

AN3-35A

Bolt

Location

Loc Qty

Loc Code

ST353

127

120644

50

120717

50

121068

27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

39.0000

2 20

D3235-1

Mounting Lug

**

9X 81970 S
11X 83311 S

Location

Loc Qty

Loc Code

ST

39

78787

39

D3278-041 Manufactured No

250 Each

68.0000

1 10

D3278-041

Support Assembly

**

B 83806 JB S

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

65

82015

40

83361

25

AN960JD416 NAS1149D0463J Purchased No

250 Each

10.0000

16 160

AN960JD416

Washer

**

16X 121255 JB S
144X 121912 S

Location

Loc Qty

Loc Code

ST351

10

116289

10

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

4 40

AN960JD516

Washer

**

119546 JB 12/06/01 S

April-25-12 10:13:02 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83774

83774

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

156.0000

2 20 ✓

AN5-36A

Bolt

Location

Loc Qty

Loc Code

340

100

121181

100

121181 S C

ST340

56

120187

6

120731

50

D2618

Manufactured

No

250

Each

190.0000

2 20 ✓

D2618

Bushing

Location

Loc Qty

Loc Code

ST012

190

76130

2

80474

188

D2230-3

Manufactured

No

250

Each

87.0000

4 40 ✓

D2230-3

Lug

Location

Loc Qty

Loc Code

ST480

87

53881

4

70973

1

81558

82

83261 JB 12/06/01

S C

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Shop Packet Print

Page 5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83774

83774

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

335.5345

1.2

12

**

D2856-400

Abrasion Strip

Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

119.5345

63735

0.6696

68076

0.3149

71164

8.46

79551

110.09

79551

cut (2) D2856-400-720 as per dwg

M521042L3

Purchased

No

250

Each

3,434.000

2

20

**

M521042L3

Nut

Location

Loc Qty

Loc Code

ST300

3434

117441

16

117885

32

118451

5

118927

3

119017

1340

119075

158

121349

880

121444

1000

121349

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 83774

83774

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

979.0000

80

**

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

979

119449

39

120187

19

120422

21

120770

400

121162

500

MS21042L5

Purchased

No

250

Each

1,307.000

20

**

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1307

116105

5

116548

43

117611

30

119109

1229

MS21042L4

Purchased

No

250

Each

5,814.000

80

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5814

116188

5

119017

4

119075

805

121011

2000

121444

3000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

40

**

AN960JD10

Washer

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED

07 06 04 *H*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

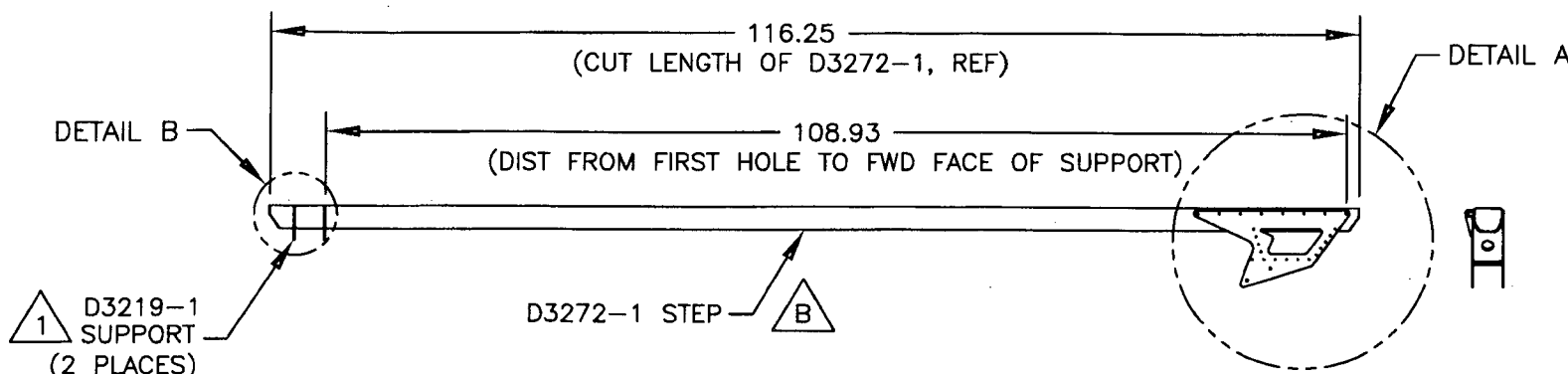
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83734 M25
12/04/26

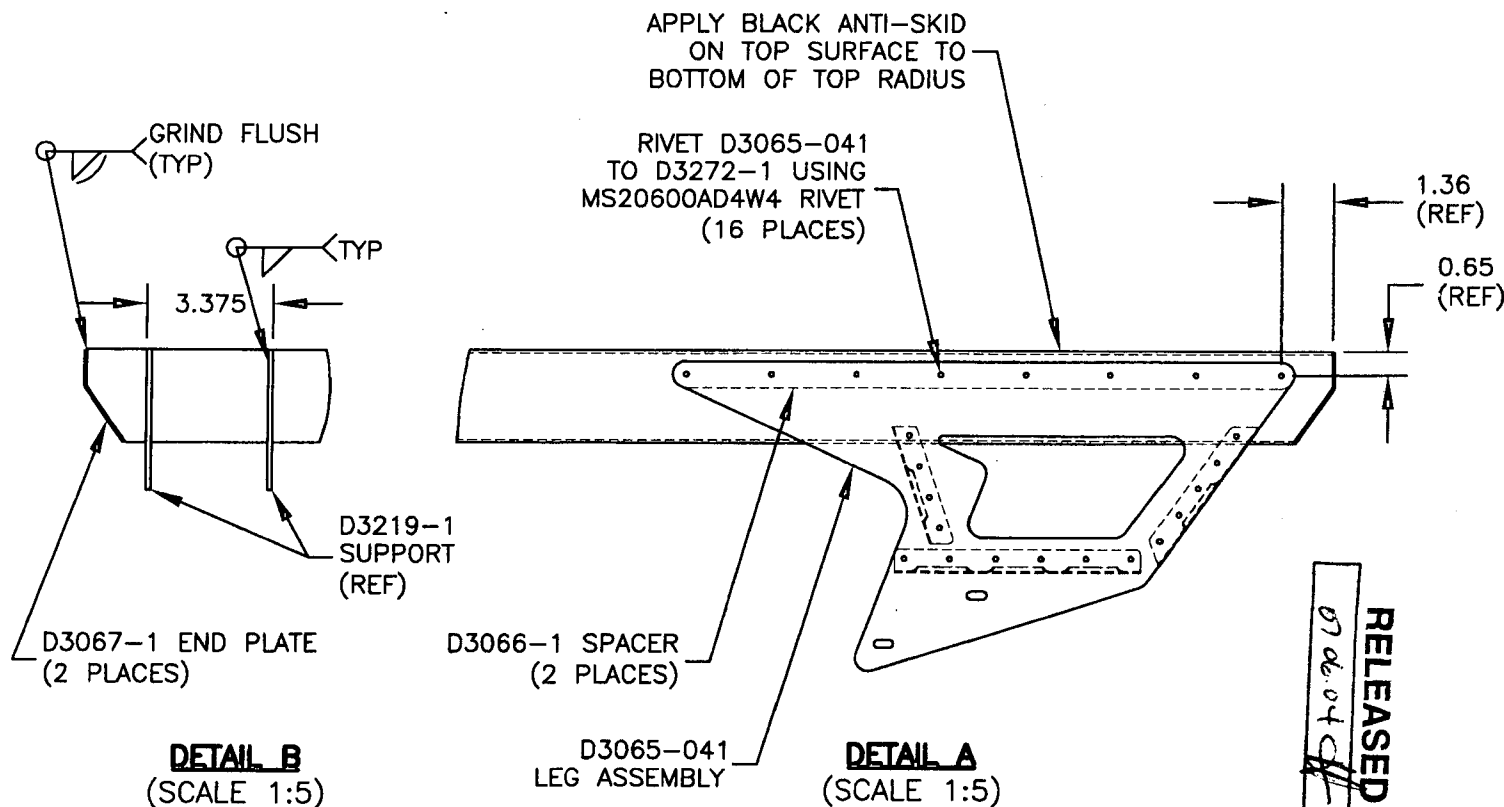
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83774



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



| | | | | |
|---------|----------|-------------|------------------------|-----------------------------|
| DESIGN | 99 | DRAWN BY | | DART AEROSPACE LTD |
| CHECKED | LE | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 07.05.18 | DRAWING NO. | D3272 | REV. B |
| | | TITLE | STEP ASSEMBLY, HI LONG | SHEET 2 OF 3 |
| | | SCALE | 1:20 | |

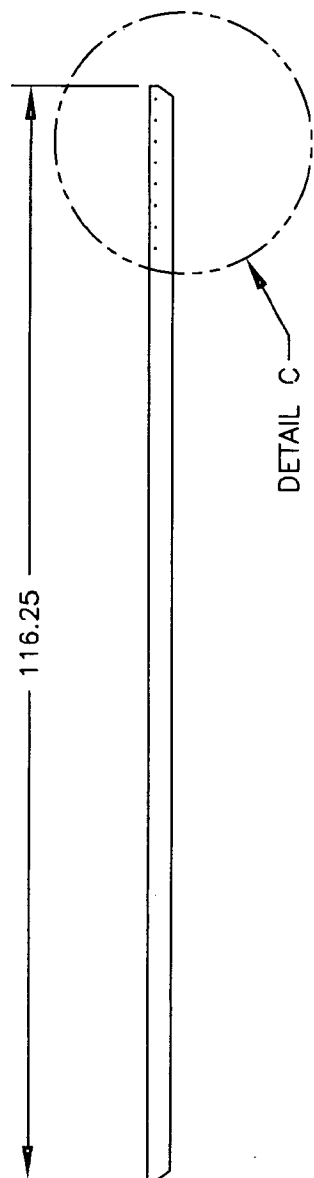
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83774
LE

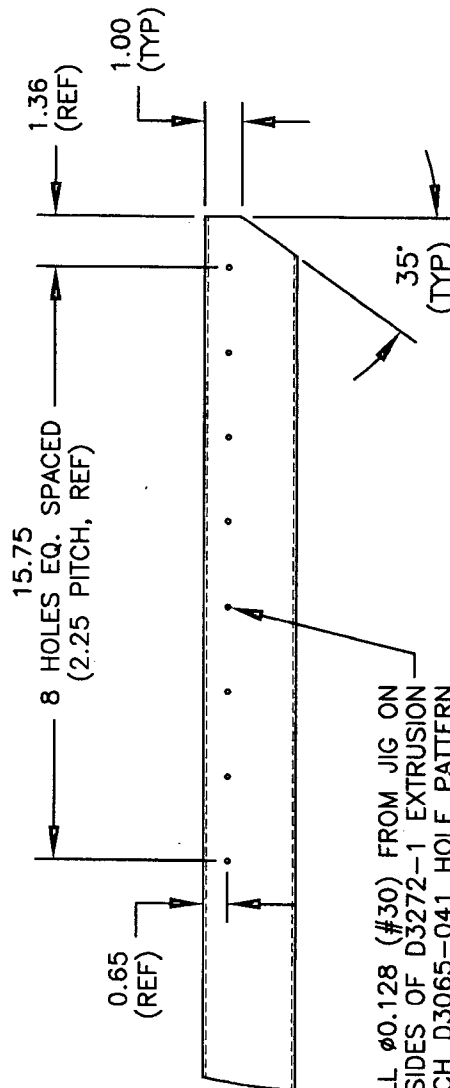


| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN qp | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED [Signature] | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

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| Qty -211 | Qty -212 | Qty -213 | Qty -214 | Qty -215 | Qty -216 | Qty -311 | Qty -312 | Part Number | Description |
|----------|----------|----------|----------|----------|----------|----------|----------|---------------|---|
| X | | | | | | | | D350-591-211 | <i>Heli-Access-Step</i> ™, Long Step – High Skid, LH |
| | X | | | | | | | D350-591-212 | <i>Heli-Access-Step</i> ™, Long Step – High Skid, RH |
| | | X | | | | | | D350-591-213 | <i>Heli-Access-Step</i> ™, Short Step – High Skid, LH |
| | | | X | | | | | D350-591-214 | <i>Heli-Access-Step</i> ™, Short Step – High Skid, RH |
| | | | | X | | | | D350-591-215 | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH |
| | | | | | X | | | D350-591-216 | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH |
| | | | | | | X | | D350-591-311 | <i>Heli-Access-Step</i> ™, Long Step – High Skid, LH |
| | | | | | | | X | D350-591-312 | <i>Heli-Access-Step</i> ™, Long Step – High Skid, RH |
| 1 | | | | | | | | D3070-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | 1 | | | | | | | D3070-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| | | 1 | | | | | | D3078-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | | | 1 | | | | | D3078-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | | | 1 | | | | D3168-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | | | 1 | | | D3168-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| | | | | | | 1 | | D3272-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | | | | | | | 1 | D3272-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| 4 | 4 | | | | | | | D2182B035 | RUBBER CUSHION |
| | | 2 | 2 | 2 | 2 | | | D2230-1 | MOUNTING LUG |
| | | 2 | 2 | 2 | 2 | 4 | 4 | D2230-3 | MOUNTING LUG |
| 8 | 8 | | | | | | | D2274 | RADIUS BLOCK |
| | | | | | | 2 | 2 | D2618 | BUSHING |
| 4 | 4 | 4 | 4 | 4 | 4 | | | D2732-030 | CUSHION |
| 2 | 2 | 1 | 1 | 1 | 1 | 2 | 2 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | | | | | | | D3064-1 | CLAMP |
| 1 | 1 | | | | | | | D3079-041 | SUPPORT ASSEMBLY |
| 4 | 4 | | | | | | | D3080-1 | CLAMP |
| | | | | | | 2 | 2 | D3235-1 | MOUNTING LUG |
| | | | | | | 1 | 1 | D3278-041 | SUPPORT ASSEMBLY |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | AN3-35A | BOLT |
| 10 | 10 | 2 | 2 | 2 | 2 | | | AN4-11A | BOLT |
| | | 4 | 4 | 4 | 4 | 8 | 8 | AN4-13A | BOLT |
| | | | | | | 2 | 2 | AN5-36A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 20 | 20 | 12 | 12 | 12 | 12 | 16 | 16 | AN960JD416 | WASHER |
| | | | | | | 4 | 4 | AN960JD516 | WASHER |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 10 | 10 | 6 | 6 | 6 | 6 | 8 | 8 | MS21042L4 | NUT |
| | | | | | | 2 | 2 | MS21042L5 | NUT |
| | | | | | | 1 | 1 | *DSI 9410-011 | STEP MODIFICATION KIT |

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.